

This side is also provided with feet, and has a finished pad against which the work is held. The locating pins extend clear through the central portion of the jig body, and consequently, will locate the component part of the work in exactly the same position as the piece of work drilled on the front side of the jig. The same clamping straps are used, the screws being simply put in from the opposite side into the same tapped holes as are used when clamping on the front side of the jig. The four holes /; arc guide holes for drilling the screw holes in the work, these being drilled the body size of the bolt in one part, and the tap drill size

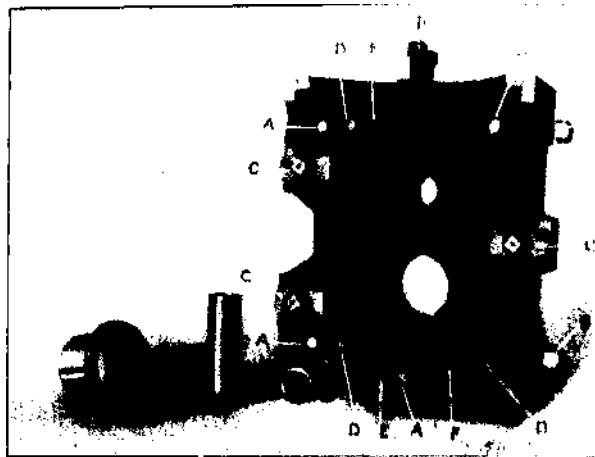


Fig. ii. Example of Open Drill Jig, View showing Front Side

in the component part. The lining bushing in the holes 1) serves as a drill bushing for drilling the body size holes. The loose bushing E, Fig. n, is used when drilling the tap holes in the component part, the inside diameter of this bushing being the tap drill size, and the outside diameter a good fit in the lining bushing. The two holes F, Fig. u, are provided with drill bushings and serve as guides when drilling the dowel pin holes, which are drilled below size, leaving about 0.010 inch, and are reamed out after the two component parts of tin* work are put together. The two holes shown in the middle of the jig in Fig. ii, which are provided with lining bushing*, and also with loose bushings, as shown inserted in Fig. i *, may be used for